ESAB

CERTIFICATE OF ANALYSIS

CERTIFICATE OF TYPICAL ANALYSIS

ORDER # : 0
PART NUMBER: 255011264

CUSTOMER NAME:

DIAMETER & LENGTH: 1/8
TRADE NAME: ATOM ARC
TYPE : 7018-1
LOT NO: 4A717B01
HEAT NO: 06301762-1
CLASSIFICATION : E 7018-1H4R
AWS A5.1-91,ASME SFA 5.1

CHEMICAL ANALYSIS :

	PROPERTIES	SPEC. REQUIREMENTS
Carbon	.04	
Manganese	1.36*	1.60
Silicon	.38	.75
Phosphorus	.010	
Sulphur	.015	
Chromium	.04*	.20
Nickel	.03*	.30
Molybdenum	.02*	.30
Vanadium	.01*	.08
Copper	.04	.30

*Sum total of noted elements shall not exceed 1.75%

RADIOGRAPHY :
XRAY Satisfactory

MOISTURE :
1800F PRIOR : .07% EXPOSED :
CONCENTRICITY : 2%

DIFFUSIBLE HYDROGEN :
AVERAGE : 0.034 (ml/100gr Avg).
AVERAGE 2 : 0

TENSILE REQUIREMENTS:
AS WELDED
MIN YIELD(psi) : 58000
MIN YIELD(MPa) : 399
MIN TENSILE(psi) : 70000
MIN TENSILE(MPa) : 482 MAX TENSILE(MPa) :
MIN ELONG : 22.0

TENSILE RESULTS :

	AS WELDED
CALCULATE YIELD(psi) :	67700
CALCULATE YIELD(Mpa) :	467
CALCULATE TENSILE(psi) :	79800
CALCULATE TENSILE(Mpa) :	551
% ELONGATION :	30.0

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By: K. Wildasin
K. Wildasin, Supervisor, Q.A. Services

ISO 9001 QMI REGISTERED QUALITY SYSTEM

SAMPLE

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ORDER # : 0
PART NUMBER: 255011264

% REDUCTION OF AREA : 80.3

CHARPY V-NOTCH REQUIREMENTS:
AS-WELDED :

CVN TEMPERATURE (F) :	-50
CVN TEMPERATURE (C) :	-46
CVN AW MIN (FT-LBS) :	20
CVN AW MIN (JOULES) :	27

CHARPY V-NOTCH RESULTS:
AS-WELDED :

TEMP(F)	FT-LBS	TEMP(C)	JOULES	GAS
-50	91	-46	123	

FILLET : Satisfactory

This material is certified to be free of any mercury.
The undersigned certifies that the product supplied will meet the requirements of the applicable AWS Filler Metal Specification when tested in accordance with that specification, and that no significant change has been made in the elements described in the qualification approval

SAMPLE

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